Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3537-3
Job Sheet 195811

Part No: D3537-3 **Job Qty:** 12 pcs
Part Name: Wearpad
Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 5/30/19 **Job Tracking No:**
Due Date: 7/3/19 **Created By:** Kimberley Guerin
Type: Stock **Description:**
Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 AUTOMATED PROCESS DD VERF:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	**Waterjet - Flow - 1**	12 pcs		7/3/19	0.17	0.72	Waterjet - Flow	69	DAS 7/03/19 9-89
120	**QC 8**	12 pcs		7/3/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		DAS 40 9-89
							QC 8 - 40		JUL 04 2019
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	**Small Fab - Brake NC - B4B**	12 pcs		7/3/19	0.25	0.55	Small Fab - Brake - 1 - B4B		DAS 30 9-89 JUL 12 2019
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	**QC 5**	12		7/3/19	0.00	0.00	QC 5 - 10		

DART AEROSPACE
Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S195634
Part: D3537 – 3
Job No: 195811
Serial No/Batch: S195634
Revision: F
Inspector:
Exp Date:
Instructions: Various STC's
Date: 07/16/19

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		pcs			QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	SC 19/07/12
150	**Automated Welding - B4B**	12 pcs	7/3/19	0.00 1.07	Automated Welding - 1 - B4B	ML
160	**QC 10**	12 pcs	7/3/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	EZ
					QC 10 - 58	
					QC 10 - 9	
170	**QC 5**	12 pcs	7/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EZ
					QC 5 - 30	
					QC 5 - 40	
200	**Packaging 3-1 - Stock - B4B**	12 pcs	7/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	EZ
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 **QC 21 - SA**	12 pcs	7/3/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

JUL 17 2019 DAS 70 9-89

Part Op Descriptions: **100** - 1-Cut D3537-3 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Deburr if necessary
120 - (QC8- Inspect parts - second check)
130 - (Form as per dwg)
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 138907
160 - (QC10- Inspect visual per QSI004- ground welds)
170 - (QC5- Inspect part completeness to step on W/O)
200 - (Identify as per dwg & Stock Location:_____)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.7880 sf (.149 ea)	100-Waterjet - Flow - 1	5159674

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	357	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	5.859inches ± 0.010	5.869 5.849	5.861	
2	Wearpad	3.500inches ± 0.010	3.510 3.490	3.500	
3	Wearpad	1.965inches ± 0.010	1.975 1.955	1.970	
4	Wearpad	2.795inches ± 0.010	2.805 2.785		
5	Wearpad	3.625inches ± 0.010	3.635 3.615	3.624	
6	Wearpad	0.220inches ± 0.010	0.230 0.210	0.221	
7	Wearpad	0.380inches ± 0.010	0.390 0.370	0.376	
8	Wearpad	0.063inches ± 0.010	0.073 0.053	0.060	

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